www.dmgmori.com

DMG MORI

Horizontal precision centres

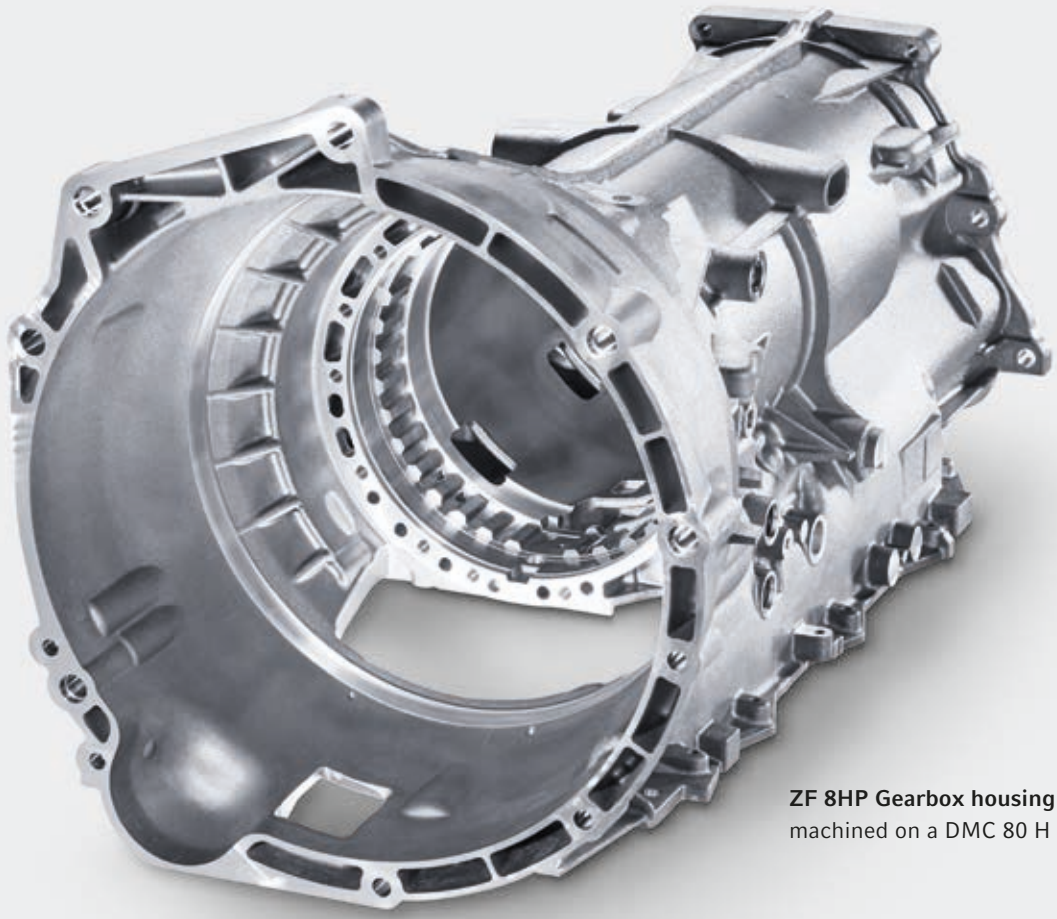
DMC 60 H *linear*
DMC 80 H *linear*

DMC H *linear* series

DMC 60 / 80 H *linear*

From powertrain to mould making.

The applications of the DMC H *linear* series range from efficient machining of complex automotive components on production lines to dynamic 5-axis simultaneous machining of mould components. Production lines in the automotive industry rely on highly accurate, fast machining centres. By using low-maintenance linear drives, the DMC H *linear* machines can achieve positioning accuracies of up to 5 µm and acceleration of up to 1 g in all axes. With or without a pallet changer, thanks to the swivelling rotary table with a swivel angle of 225°, the DMC 60 / 80 H *linear* is ideal for machining complex free-form surfaces quickly and efficiently in one clamping.



ZF 8HP Gearbox housing
machined on a DMC 80 H *linear*

Mechanical engineering

Control housing

Automotive

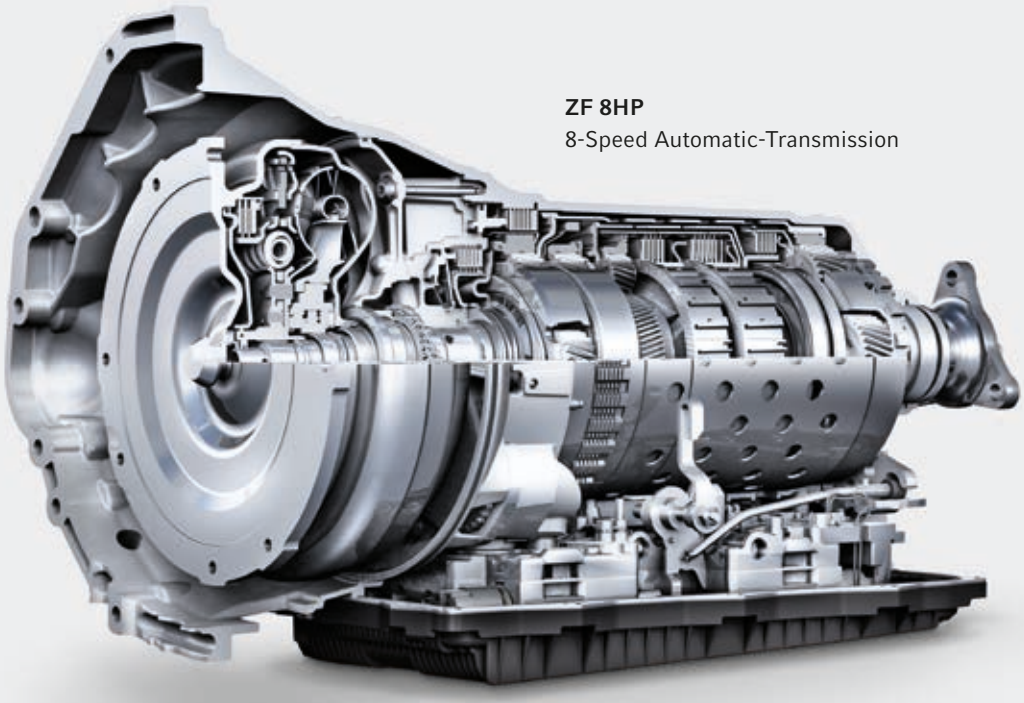
Cylinder head

Mould making

Forging die for connecting rods

Aerospace

Structural component



ZF 8HP
8-Speed Automatic-Transmission

DMC 60 / 80 H *linear*

Outstanding!

Whether an application calls for high productivity or flexibility, DMC 60 / 80 H *linear* horizontal machining centres are the solution. Linear drives in all main axes, with rapid traverses of up to 100 m/min and accelerations of up to 10 m/s², generate the best dynamics and incredible precision. The unrestricted crane loading system on machines with a pallet changer, easy visibility into the working area and the optimally accessible central service unit underpin the outstanding ergonomics of these machines and tick all the boxes for productive applications.

5 axis CHAMPION

linear DRIVE

Please note: the results of machining and performance trials listed in this catalogue are to be taken as examples. The results may vary slightly due to the site conditions and cutting conditions.

Productive

+ Linear drives in all axes with rapid traverse of up to 100 m/min and acceleration of up to 10 m/s²
+ Chip-to-chip time from 2.5 seconds
+ Direct chip disposal to the rear through the machine bed
+ Off-line programming during machining
+ Off-line programming block by block

Precise

+ Long-term accuracy thanks to linear drives with a positioning accuracy of up to 5 µm and repeatability of up to 3 µm
+ Cooled linear drives, guideways, swivelling rotary table and main drive

DMC H *linear*

Productive
Precise
Flexible

+ Machine bed 3,900 kg (DMC 60 H *linear*) / 5,000 kg (DMC 80 H *linear*)
+ Stepped travelling column for optimum strength

Flexible

+ With either an NC rotary table or a swivelling rotary table for 5-axis simultaneous machining
+ With and without a pallet changer
+ Wheel magazine with up to 363 positions

+ Easy to integrate into existing lines
+ Five motor spindle models ranging from 20 to 52 kW
+ Powertrain version with direct loading from the top and front

Applications and parts
Highlights
› Productive
Control technology
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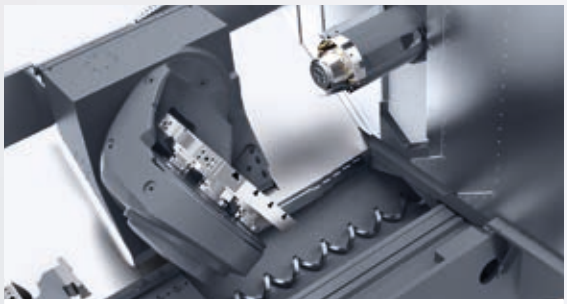
DMC 60 / 80 H *linear*

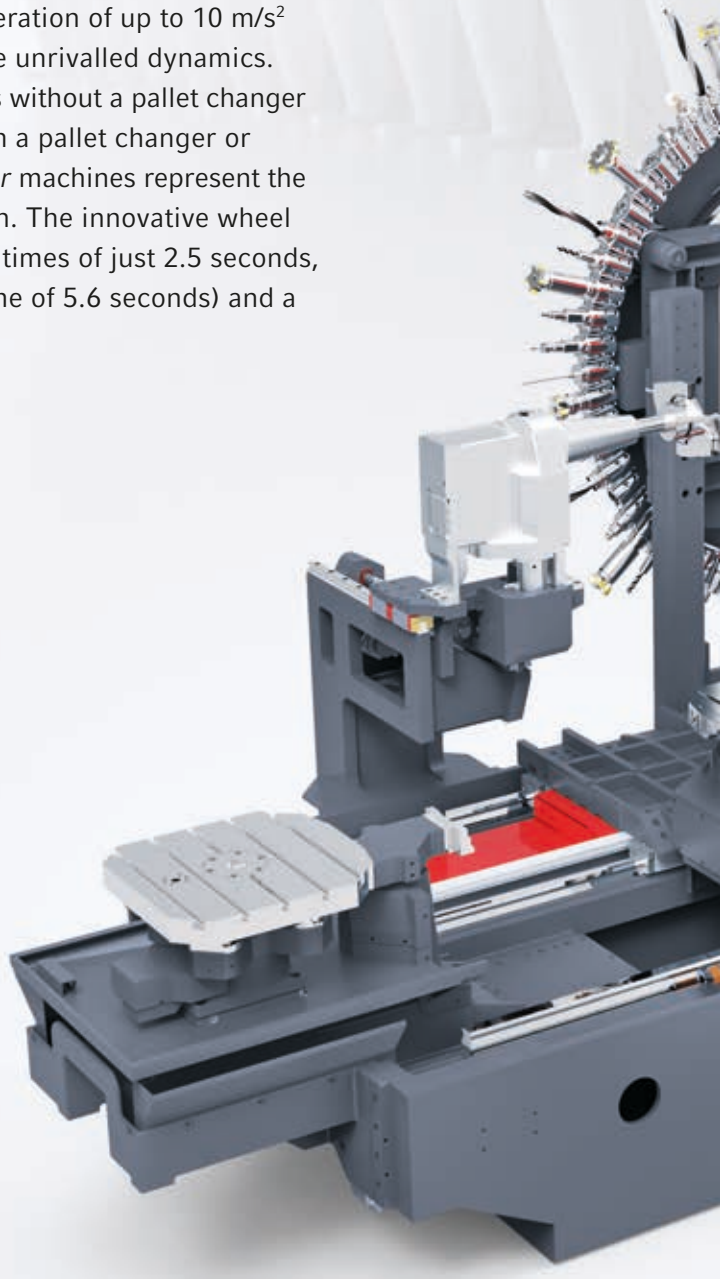
Maximum productivity!

Innovative features and an optimised technical design. The high-efficiency horizontal machining centres show why they are the best: linear drives in all axes with rapid traverses of up to 100 m/min, acceleration of up to 10 m/s^2 and a weight-optimised travelling column guarantee unrivalled dynamics. Thanks to the innovative machine concept, machines without a pallet changer can be optimally integrated into a transfer line. With a pallet changer or rotary storage (up to 12 pallets), DMC 60 / 80 H *linear* machines represent the optimal solution for efficient stand-alone automation. The innovative wheel magazine boasts additional highlights: chip-to-chip times of just 2.5 seconds, tool call-up during machining (maximum call-up time of 5.6 seconds) and a 50 % smaller footprint.

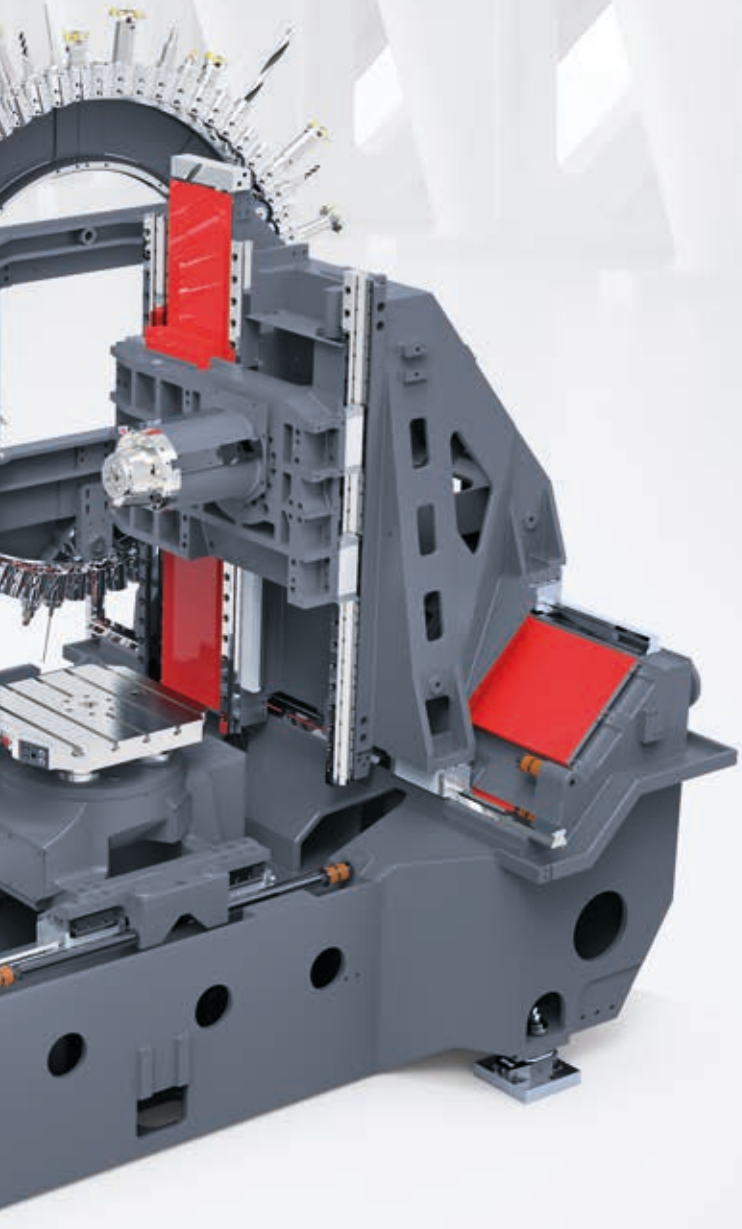


Optimal chip removal

Horizontal machining allows for optimal chip removal. The steep angle of the covers and the open machine bed facilitate direct chip removal into the chip conveyor, resulting in higher process safety, longer tool lives, better heat dissipation and better finishes on the machined surfaces.



Productive
Precise
Flexible

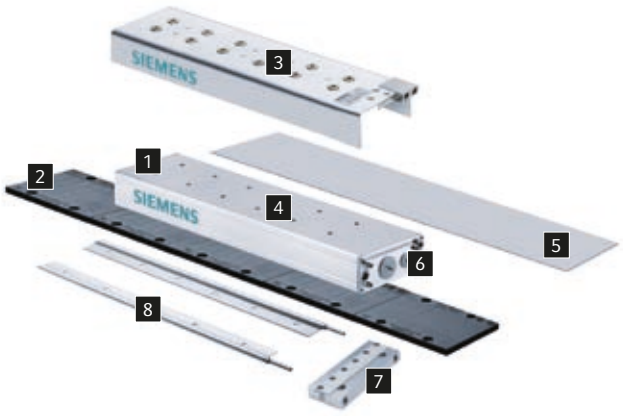


linear DRIVE

25 % more productivity and precision thanks to linear drives

+ **Linear drives:** maximum long-term accuracy, minimal maintenance costs and a 60-month warranty on the linear drives
+ **Dynamics:** up to 100 m/min rapid traverse and up to 1 g acceleration (DMC 60 H *linear*)
+ **Precision:** positioning accuracy of up to 5 µm and repeatability of up to 3 µm

Linear drives with acceleration of up to 10 m/s²



- Primary section
- Secondary section
- Precision cooler
- High-performance cooler
- Secondary section cover
- End cover
- Combi distributor
- Cooling profiles

Applications and parts
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› Precise
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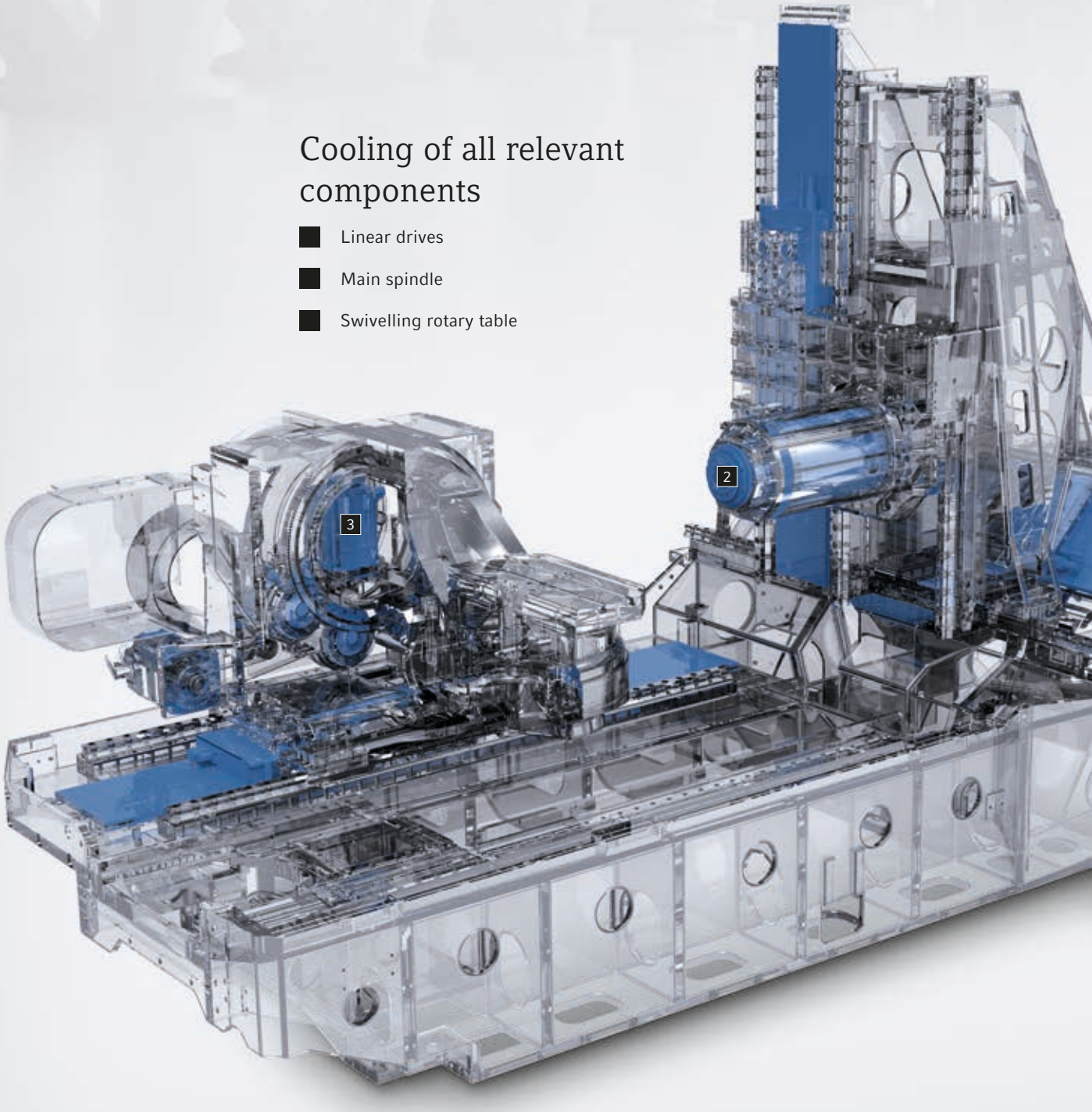
Productive
Precise
Flexible

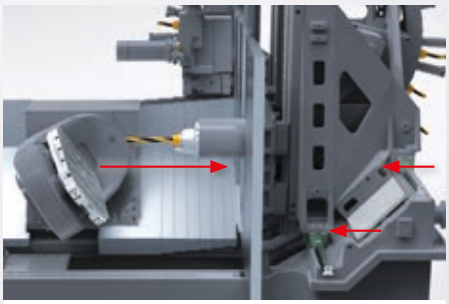
Cooling of all relevant components

- Linear drives
- Main spindle
- Swivelling rotary table



High long-term precision!

The outstanding precision is achieved by cooling all relevant components as well as the highly stable design. All linear drives, the NC rotary table or NC swivelling rotary table and the main spindle are cooled. Additionally, the linear guideways are cooled on the model with ball screws. The FEM optimisation of the inherently stiff machine bed and all moving components maximise the overall stiffness of the machine. In combination with the wear-free drives, the machine achieves a positioning accuracy of up to 5 µm and repeatability of up to 3 µm. Additionally, the inherently stiff machine bed with three-point support ensures quick and trouble-free set-up.



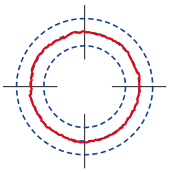
Highly stable design

The stepped travelling column and inherently stiff machine bed allow optimal distribution of forces.

Maximum precision – linear drives for maximum long-term accuracy

+ Circularity accuracy* of up to **5 µm**
+ Positioning accuracy of up to **5 µm**
+ Repeatability of up to **3 µm**

* X / Y with F = 3,000 mm/min and R = 150 mm



Applications and parts
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DMC 60 / 80 H *linear*

Flexible for every application!

The modular concept of the DMC 60 / 80 H *linear* allows the user to adapt the machine to suit any application. With or without a pallet changer, four axes or five and with linear drives or ball screws, the DMC 60 / 80 H *linear* can complete any demanding production task. Additionally, the wide range of motor spindles allows the machine to process a variety of materials including steel, cast iron and aluminium.

NC rotary table with powertrain connection

+ Highly productive 4-axis machining
+ Ideal for automation solutions in series production

Swivelling rotary table

+ Universal machining centre for flexible requirements
+ 5-axis simultaneous machining of complex components

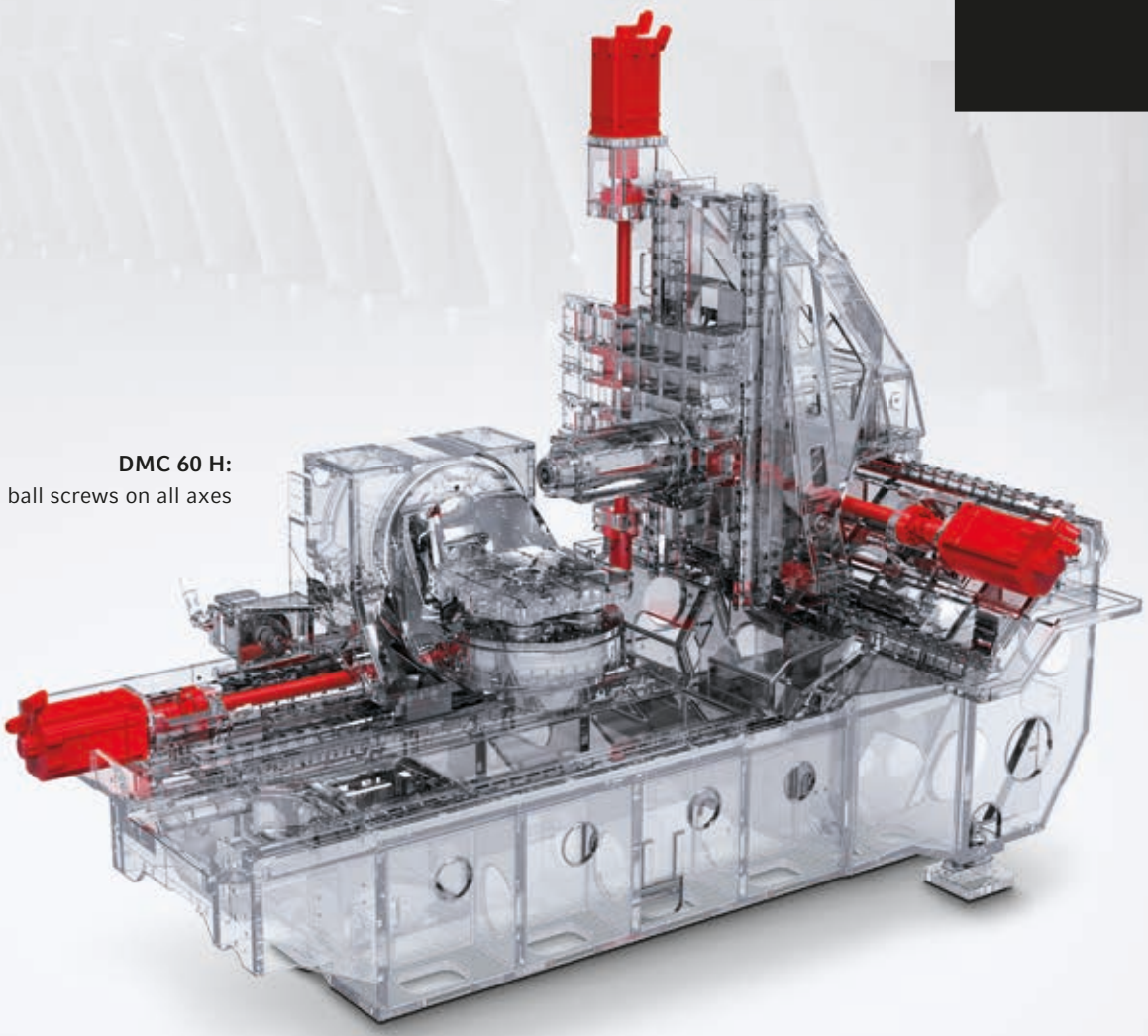
NC rotary table with pallet changer

+ Automated 4-axis machining centre
+ Ideal for 4-sided machining in small batches

Swivelling rotary table with pallet changer

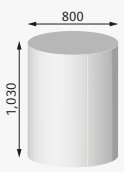
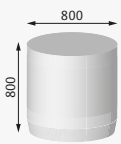
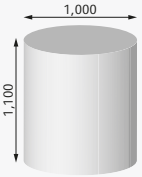
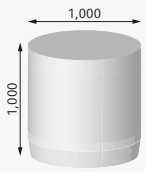
+ Universal machining centre with integrated automation for high productivity
+ 5-axis simultaneous machining of complex components in small batches

Productive
Precise
Flexible



DMC 60 H:
ball screws on all axes

Working area

		DMC 60 H *linear*		DMC 80 H *linear*	
		4 axes	**5 axes**	**4 axes**	**5 axes**
Travel X / Y / Z	mm	630 / 800 / 850	630 / 800 / 750	800 / 900 / 1,050	800 / 1,000 / 1,050
Table / pallet	mm	ø 630 / 500 × 500	ø 630 / 500 × 500	ø 900 / 630 × 630	ø 900 / 630 × 630
Maximum load	kg	600 / 650*	400 / 450*	900 / 950*	600 / 650*
Workpiece dimensions	mm				

* Powertrain variant without pallet changer

DMG SLIM*line*® Control

High-end CNCs for safe processes and maximum precision.

Intelligent control systems are indispensable when it comes to achieving maximum process efficiency, attaining the highest component precision and providing optimal user-friendliness. DECKEL MAHO relies on Siemens and Heidenhain and provides the 840D solutionline or TNC 640 for the DMC 60 / 80 H *linear*. Certain software solutions such as DMG Virtual Machine or the DMG process chain can also improve workpiece quality and productivity.

DMG SLIM*line*® Control with Siemens 840D solutionline

+ The simplest interactive programming
+ SINUMERIK Operate new user interface
+ ATC*, 3D quickSET®*
+ With powerful new functions for setting up, programming and tool and program management
+ Rapid block processing time of 0.6 ms
+ DIN / ISO ShopMill brought together under one roof

* Optional

DMG SLIM*line*® Control with Heidenhain TNC 640

+ Unique, highly detailed 3D simulation display
+ New optimised TNC user interface
+ HSCI – HEIDENHAIN Serial Controller Interface
+ Workshop or DIN-ISO programming
+ Rapid program generation with plain-text programming
+ Graphical programming
+ CollisionMonitoring (DCM)
+ ATC*, 3D quickSET®*

* Optional

MPC – Machine Protection Control

Protecting machines with an emergency shut-off function

Vibration sensors on the milling spindle

Emergency shut-off function with teach function

Process monitoring by means of a bar graph

Milling spindle bearing diagnostics

MPC Machine Protection Control

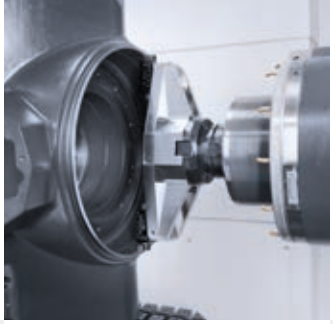
SGS – Spindle Growth Sensor

Improved precision by measuring and compensating for spindle displacement

Measurement of the axial displacement of the rotor compared to the stator in real time

The CNC control system compensates for the actual displacement

SGS Spindle Growth Sensor



SIS – Spindle Interface System

Detection of contamination with chips in the HSK tool interface

Increased process safety for precision machining

Fewer machining errors

Chip detection on the face and taper

SIS Spindel Interface System

ATC – Application Tuning Cycle

Process optimisation at the push of a button

Process-oriented feed drive tuning

Minimised machining time with maximised component quality, irrespective of workpiece weight

ATC Application Tuning Cycle

Exclusive, optionally available DMG MORI technology cycles

3D quickSET®

Quick and easy for the highest precision

Tool kit for checking and correcting the kinematic precision of 4- and 5-axis machine configurations

All head variants and all table axes

3D quickSET

Grinding

Machining with the highest surface precision

Grinding on a universal milling machine

For internal, external and surface grinding

Truing cycles for truing the grinding wheel

Interpolation turning

Machining of faces and recesses without a turn-mill table

The machining process takes place in a circular movement around or within the workpiece

The spindle is perpendicular to the direction of movement

Efficient Production Package

Safe and efficient production – optimisation of production potential

Extended milling strategies

Simple programming of repeating machining steps

Safe retraction from all breakage situations

Reduced programming times

DMC 60 / 80 H *linear*

The modular system for all production requirements.

With its modular system, the DMC 60 / 80 H *linear* can be adapted to suit your requirements.

		DMC 60 H *linear*	DMC 80 H *linear*
NC rotary table powertrain configuration			
Table size	mm	ø 630	ø 900
Max. load	kg	650	950
B axis torque	Nm	3,060	6,350
B axis speed	rpm	40	40

Swivelling rotary table powertrain configuration			
Table size	mm	ø 630	ø 900
Max. load	kg	450	650
B axis torque	Nm	3,535	6,782
B axis speed	rpm	40	40
A axis torque	Nm	3,991	8,322
A axis speed	rpm	20	25

NC rotary table with pallet changer			
Table size	mm	500 × 500	630 × 630
Max. load	kg	600	900
B axis torque	Nm	3,600	6,350
B axis speed	rpm	40	40

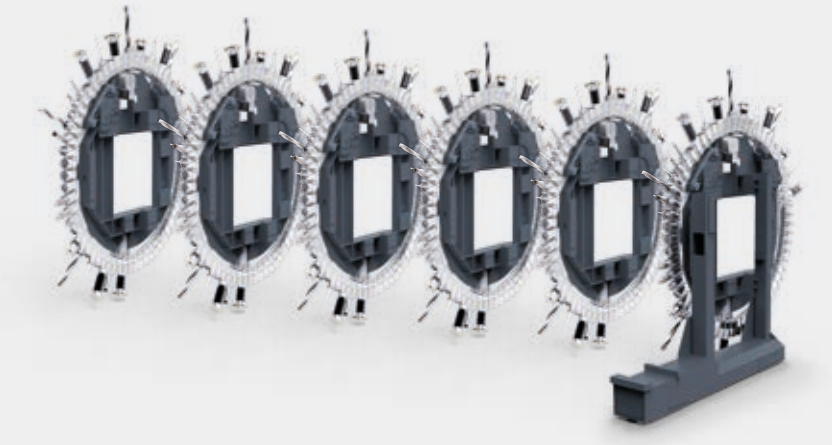
Swivelling rotary table with pallet changer			
Table size	mm	500 × 500	630 × 630
Max. load	kg	400	600
B axis torque	Nm	3,535	6,782
B axis speed	rpm	40	40
A axis torque	Nm	3,991	8,322
A axis speed	rpm	20	25

Spindles

(torque and power at 40 % duty cycle)

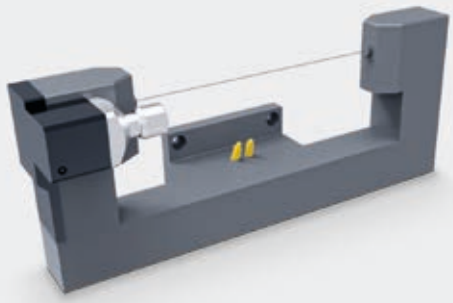
12,000 rpm 110 Nm / 20 kW HSK-63	12,000 rpm 288 Nm / 44 kW HSK-100	12,000 rpm 430 Nm / 52 kW HSK-100	10,000 rpm 200 Nm / 46 kW HSK-63*	18,000 rpm 110 Nm / 34 kW HSK-63*

Tool magazines



40 / 63 / 123 / 183 / 243 /
303 / 363 tools

Workpiece measurement



Blum Laser tool measurement
in the working area

Production

Chip conveyor

980-litre coolant / lubricant system

Clamping hydraulics

2 channels proportional; 2 / 4 channels;
4 channels proportional; 4 / 7 channels

* Optional HSK-100 only for the DMC 80 H *linear*

DMC 60 / 80 H *linear*

Automation solutions for all requirements.

With direct loading from the front and top, the DMC 60 / 80 H *linear* is ideal for automation. The four and five-axis machines also have the same loading height.

Direct loading

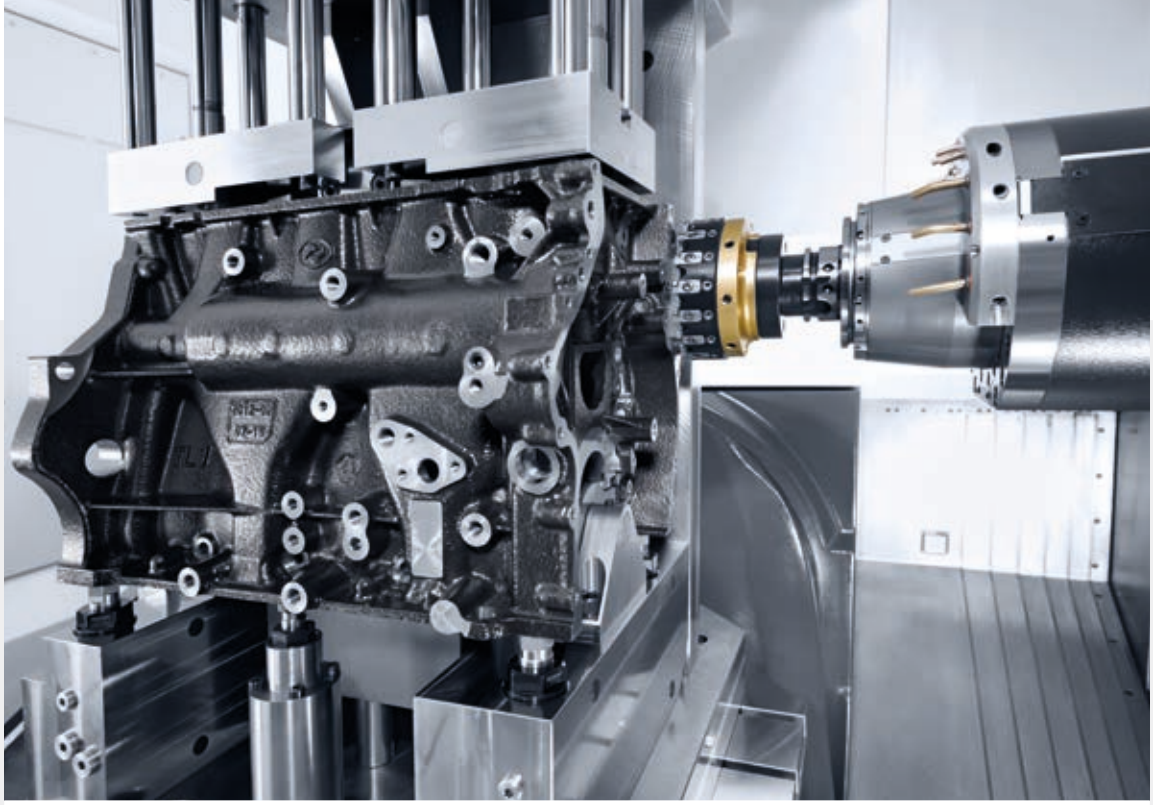
Application: high quantities
Component variety: low
(identical components)

+ Cost-effective solution
+ Fixed operational sequence
+ Manual loading
+ Difficult to convert

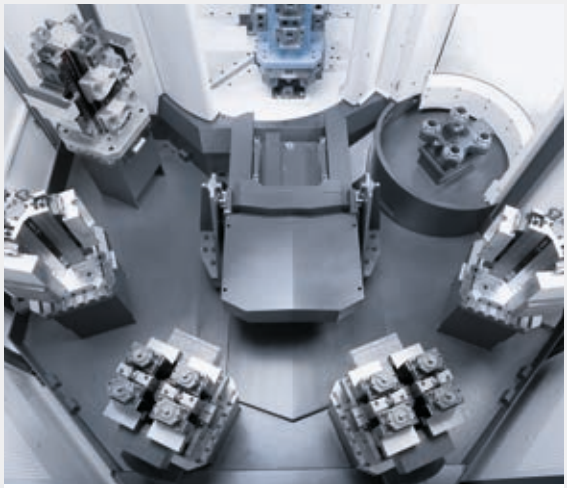
Robot solutions

Application: high quantities
Component variety: similar

+ Rapid handling with the 6-axis robot
+ Multiple machining centres can be connected
+ Minimal staff requirement
+ Flexible addition of extra processes (deburring, marking, measuring)
+ Specialists required to program the robot



Transfer line production: optional bespoke hydraulic clamping is provided for rapid and safe workpiece fixturing.



Rotary storage

Application: from batch sizes of 1
Component variety: high

+ Offline set-up at the external workpiece load / unload station
+ Can be expanded
+ Low staff requirement

Portal loading

Application: high quantities
Component variety: low (identical components)

+ Potentially long transfer routes
+ Fixed operational sequence
+ Low staffing levels possible
+ Potentially difficult conversion
+ All processes can be displayed

Applications and parts
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› 5-axis machining
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DMC 60 / 80 H *linear*

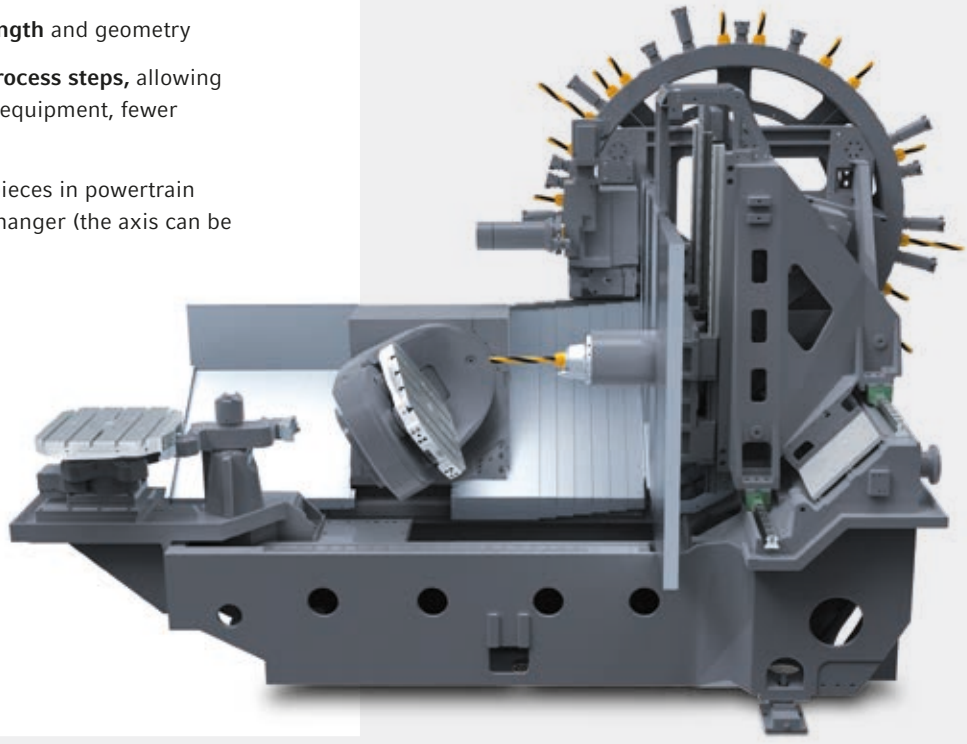
Highly productive 5-axis complete machining.

With its swivelling rotary table with a swivel angle of 225°, the DMC 60 / 80 H *linear* can fully machine workpieces weighing up to 650 kg in one clamping. This flexibility allows the machine to achieve the highest levels of precision and the shortest machining times.

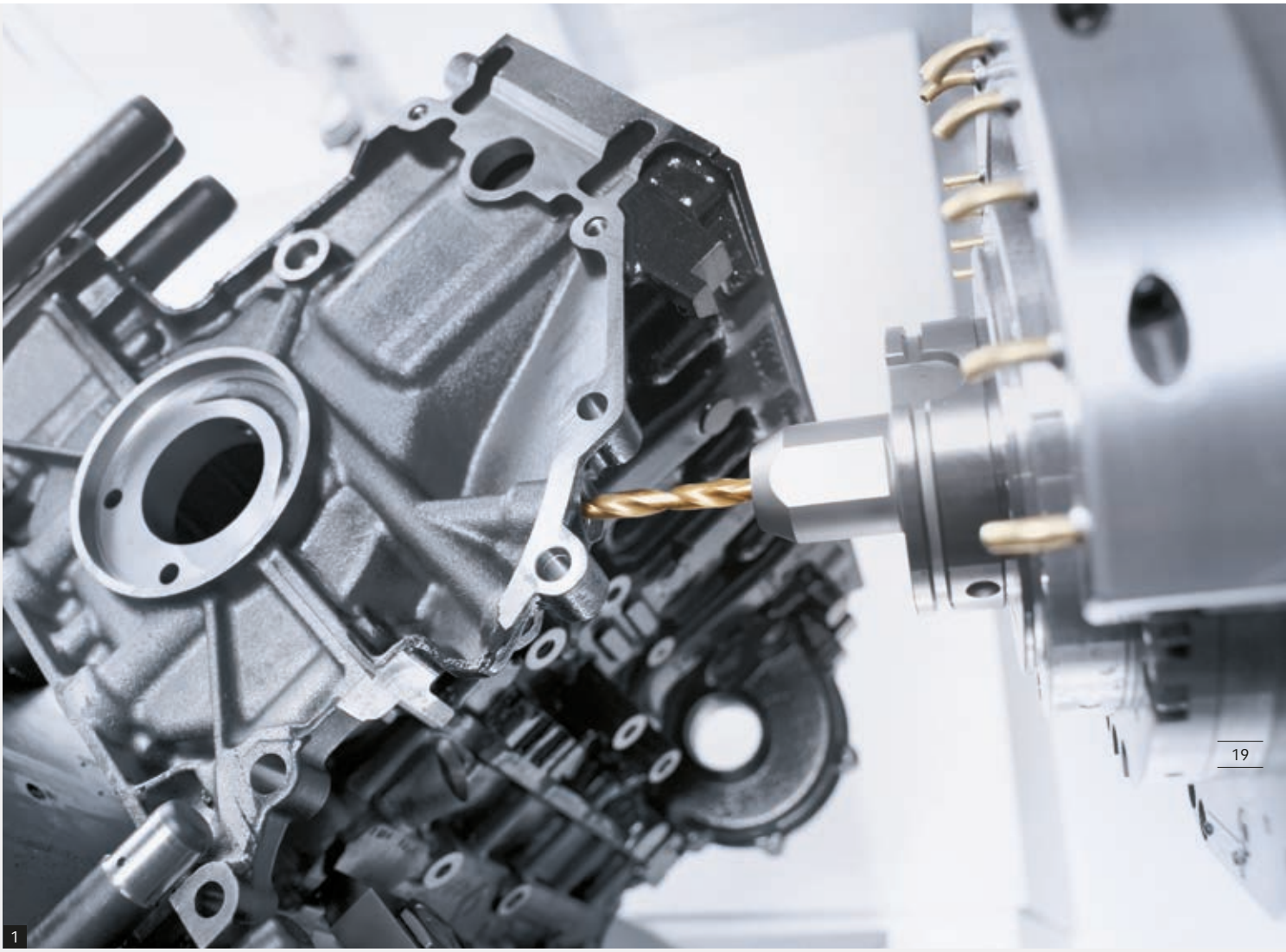
Advantages of 5-axis / 5-sided machining

+ Can machine **positive angles and negative angles up to –25°**
+ Machining of **complex forms and prototypes**
+ **Higher precision through complete machining** in one clamping
+ **Optimal design of tool length** and geometry
+ **Optimal sequencing of process steps,** allowing **efficient machining** (less equipment, fewer machines and tools)
+ **Flexible loading** of workpieces in powertrain machines with no pallet changer (the axis can be swivelled during loading)

5 axis CHAMPION



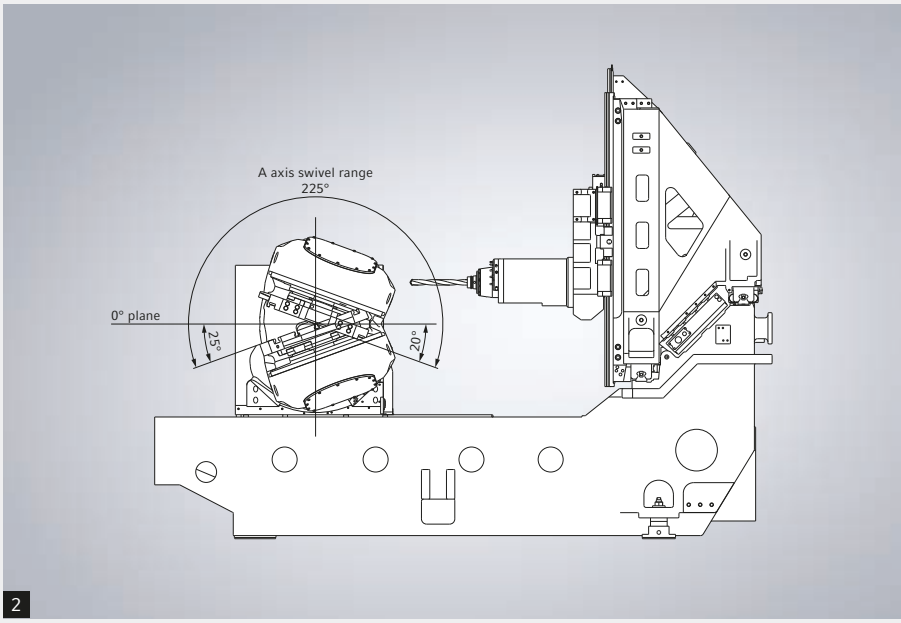
1: 5-axis machining of a crankshaft housing with the 10,000 rpm motor spindle rated at 200 Nm **2:** 5-axis version



1

5-axis version

+ **Traverse X / Y / Z:** 800 / 900 / 1,050 mm (DMC 80 H *linear*)
+ **Workpieces up to ø 1,000 × 1,000 mm / 600 kg**
+ Identical workpiece measurements and traverses in the powertrain machine or the machine with pallet changer



2

Applications and parts
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› Maintenance
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Clear and ergonomic

Fluid box: the central maintenance unit has been designed to be easily accessible for the operator.

DMC 60 / 80 H *linear*

High availability through ease of maintenance.

- **All drives are outside the working area**
  Optimal accessibility; no heat influence to ensure high levels of precision; avoidance of contamination by coolant or chips
- **Maintenance area behind the travelling column**
  The control cabinet 30 cm behind the travelling column provides perfect accessibility – such as when replacing a spindle – and easy access to the release unit
- **Cable carrier high outside the working area**
  Prevents contamination with coolant or chips from the working area or tool magazine
- **Pallet changer drive underneath the actual pallet changer**
  Prevents contamination and ensures optimal accessibility
- **Central lift and drive of the pallet changer in the centre of mass**
  For higher stability and less wear

Applications and parts
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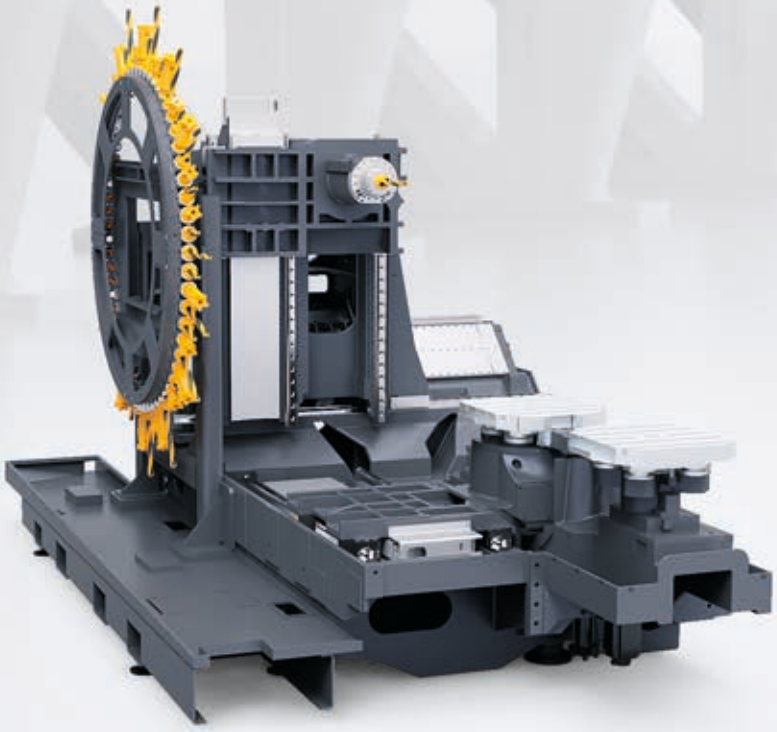
› Wheel magazine
Technical data

DMC 60 / 80 H *linear*

The wheel magazine: modular design and the shortest chip-to-chip times.



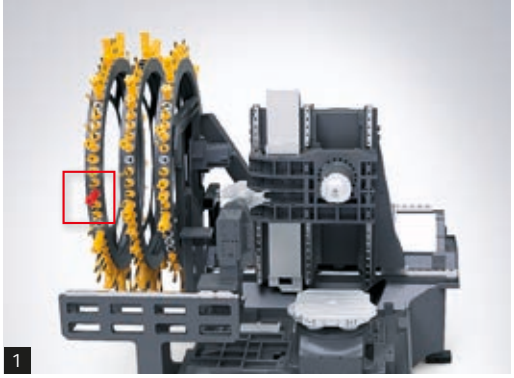
Highlights

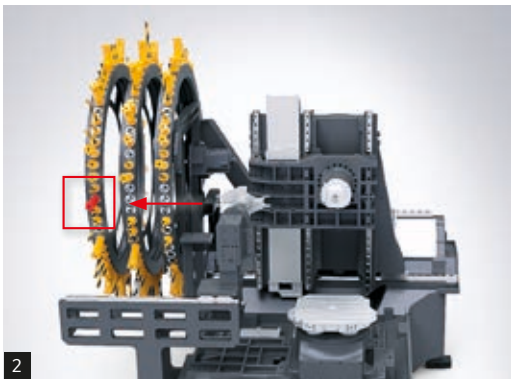
+ **Chip-to-chip time of 2.5 seconds** (on the DMC 60 H *linear*)
+ **Tool call-up even from the outer wheel entirely during the machining cycle** (from 123 tools)
+ **Max. tool call-up time of 5.6 seconds** for the furthest tool
+ One wheel with **40 tools as standard**
+ Can accommodate up to five wheels and **363 tools** (on the DMC 80 H *linear*)
+ Taper cleaning **and mechanical** tool breakage monitoring **during machining**
+ Tool dimensions:
  max. length **650 mm;**
  max. diameter **ø 400 mm;**
  max. tool weight **40 kg** (HSK-A100);
  max. breakdown torque **25 Nm**

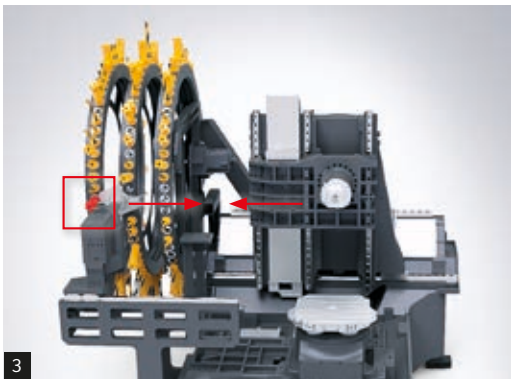
Machine configuration levels

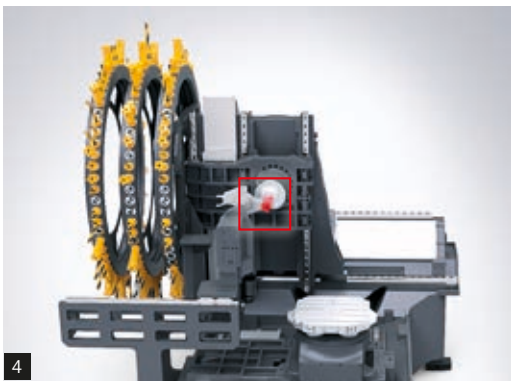
	1 magazine wheel	2 magazine wheels	3 magazine wheels	4 magazine wheels	5 magazine wheels
DMC 60 H *linear* (HSK-A63)					
Wheel sizes	small / med. / large	medium	medium	medium	medium
Number of tools	40 / 63 / 80	123	183	243	303
DMC 80 H *linear* (HSK-A63)					
Wheel size	small / med. / large	medium / large	large	large	–
Number of tools	40 / 63 / 93	123 / 183	273	363	–
DMC 80 H *linear* (HSK-A100)					
Wheel size	medium / large	large	large	large	–
Number of tools	40 / 63	123	183	243	–

– Not available



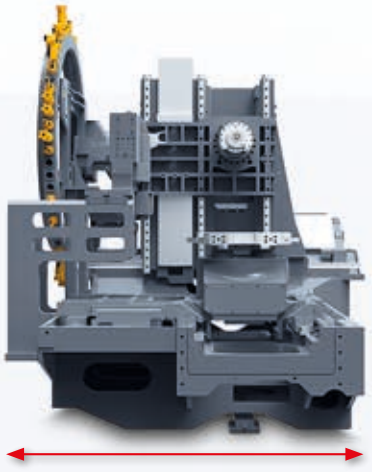






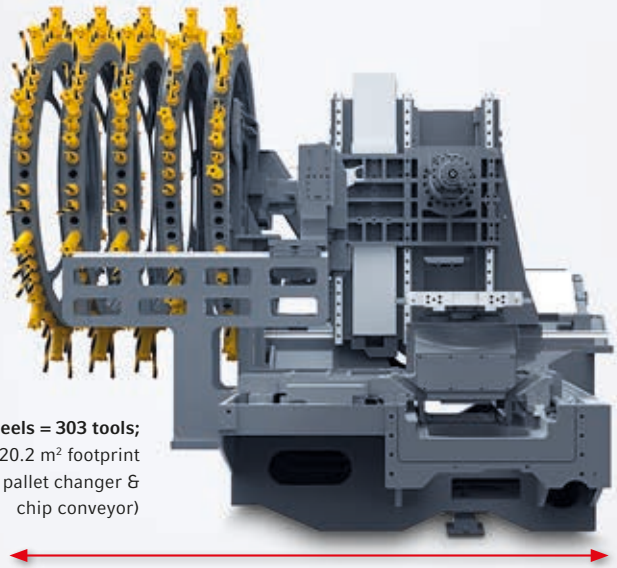
Functional principle

- The selected tool is on wheel 3
- The wheels rotate to open a path (three tools) for the shuttle
- The shuttle (double gripper) travels to the selected tool which is released from the holder
- The tool is exchanged / replaced and the double gripper returns



1 wheel = 40 tools as standard;
17.2 m² footprint
(including pallet changer & chip conveyor)

DMC 60 H *linear*: 2,500 mm



5 wheels = 303 tools;
20.2 m² footprint
(including pallet changer & chip conveyor)

DMC 60 H *linear*: 3,700 mm

From 2.5 metres in width: ideal for installation in production lines

Motor spindles for every application

The wide range of motor spindles allows for the productive machining of various materials including steel, cast iron and aluminium.

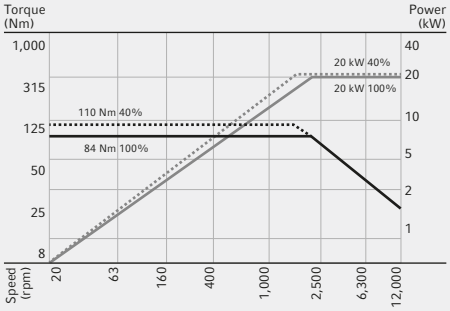
Maximum productivity with short spindle run-up times.

Spindle range		
Speed // tool holder, power // torque // spindle run-up time	**DMC 60 H *linear***	**DMC 80 H *linear***
12,000 rpm // HSK-A63, 20 kW // 110 Nm // 0–12,000 rpm: from 1.0 seconds	•	•
18,000 rpm // HSK-A63*, 34 kW // 110 Nm // 0–18,000 rpm: from 1.3 seconds	○	○
10,000 rpm // HSK-A63*, 46 kW // 200 Nm // 0–10,000 rpm: from 1.4 seconds	○	○
12,000 rpm // HSK-A100, 44 kW // 288 Nm // 0–12,000 rpm: from 4.3 seconds	–	○
12,000 rpm // HSK-A100, 52 kW // 430 Nm // 0–12,000 rpm: from 3.8 seconds	–	○

• Standard, ○ Optional, – Not available, * Also optional with HSK-A100 on the DMC 80 H *linear*

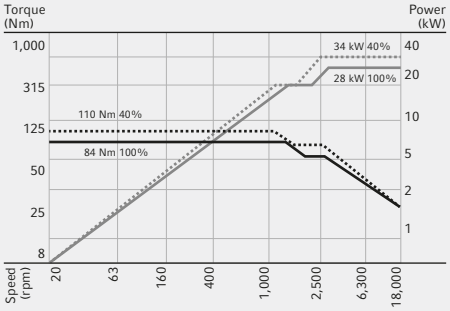
HSK-A63 motor spindle

12,000 rpm / 20 kW / 110 Nm



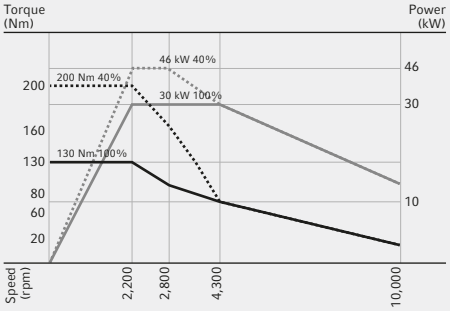
HSK-A63* motor spindle

18,000 rpm / 34 kW / 110 Nm



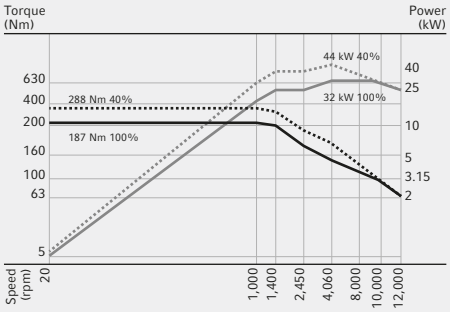
HSK-A63* motor spindle

10,000 rpm / 46 kW / 200 Nm



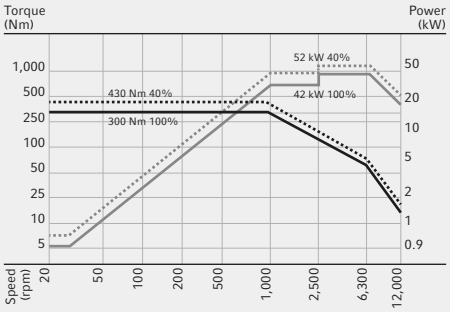
HSK-A100 motor spindle

12,000 rpm / 44 kW / 288 Nm



HSK-A100 motor spindle

12,000 rpm / 52 kW / 430 Nm



Applications and parts
Highlights
Control technology
Overview
Technical data
› Machining examples

DMC 60 / 80 H *linear*

High-performance milling, high-performance drilling and tapping in aluminium and steel.

1

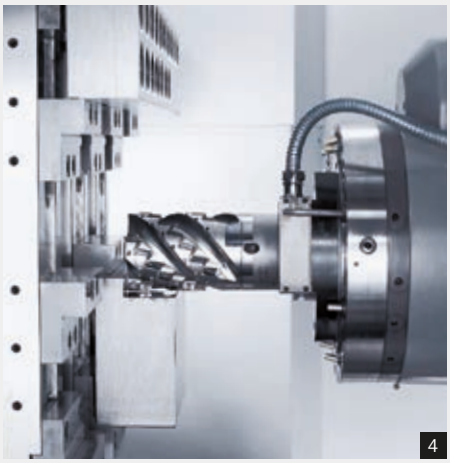
2

3

Torque spindle rated at 12,000 rpm / 44 kW / 288 Nm			
	High-performance milling	**Drilling**	**Tapping**
Workpiece material	Steel (Ck45)	Steel (Ck45)	Steel (Ck45)
Material removal rate	812 cm³/min	708 cm³/min	–
Tool	Milling head ø 100 mm (7 cutting edges)	Indexable insert drill ø 70 mm	M30 tap
Spindle speed	1,255 rpm (Vc = 394 m/min)	1,023 rpm (Vc = 255 m/min)	106 rpm (Vc = 10 m/min)
Feed	2,900 mm/min (Fz = 0.33 mm)	186 mm/min (Fz = 0.18 mm)	371 mm/min (Fz = 3.5 mm)
Cutting depth / width	3.5 / 80 mm	100 mm	30 mm

Motor spindle rated at 18,000 rpm / 34 kW / 110 Nm			
	High-performance milling	**Drilling**	**Tapping**
Workpiece material	Aluminium (AlMgSi)	Aluminium (AlMgSi)	Aluminium (AlMgSi)
Material removal rate	2,730 cm³/min	801 cm³/min	–
Machining time per thread*	–	–	1.5 seconds
Tool	Milling head ø 80 mm	Indexable insert drill ø 43 mm	M6 tap (VHM)
Spindle speed	12,000 rpm (Vc = 3,000 m/min)	2,400 rpm (Vc = 320 m/min)	2,500 rpm (Vc = 49 m/min)
Feed	6,000 mm/min (Fz = 0.125 mm)	545 mm/min (Fz = 0.23 mm)	–
Cutting depth / width	6.5 / 70 mm	70 mm	12 mm

* Including delivery and return movement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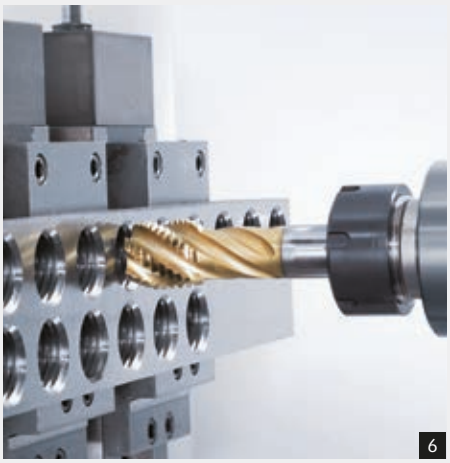

6

Motor spindle rated at 18,000 rpm / 34 kW / 110 Nm

	High-performance milling**	Drilling	Tapping
Workpiece material	Steel (Ck45)	Steel (Ck45)	Steel (Ck45)
Material removal rate	317 cm^3/min	270 cm^3/min	–
Machining time per thread*	–	–	2.7 seconds
Tool	Face mill ø 80 mm	Indexable insert drill ø 50 mm	M12 tap (VHM)
Spindle speed	1,400 rpm (Vc = 350 m/min)	1,146 rpm (Vc = 180 m/min)	875 rpm (Vc = 33 m/min)
Feed	1,500 mm/min (Fz = 0.18 mm)	142 mm/min (Fz = 0.12 mm)	–
Cutting depth / width	3 / 70 mm	75 mm	24 mm

* Including delivery and return movement, ** Reference values for the 18,000 rpm motor spindle

Motor spindle rated at 12,000 rpm / 20 kW / 110 Nm

	High-performance milling	Drilling	Tapping
Workpiece material	Steel (Ck45)	Steel (Ck45)	Steel (Ck45)
Material removal rate	1,000 cm^3/min	830 cm^3/min	–
Tool	Milling head ø 160 mm (9 cutting edges)	Indexable insert drill ø 80 mm	M42 tap
Spindle speed	1,000 rpm (Vc = 500 m/min)	900 rpm (Vc = 255 m/min)	46 rpm (Vc = 6 m/min)
Feed	1,800 mm/min (Fz = 0.2 mm)	165 mm/min (FZ = 0.183 mm)	207 mm/min (FZ = 4.5 mm)
Cutting depth / width	4.5 / 120 mm	–	–

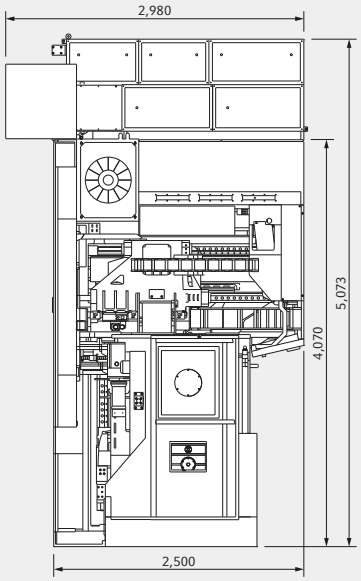
DMC 60 / 80 H *linear*

Floor plans

DMC 60 H *linear*
Powertrain machine with no pallet changer (optional)

Plan view with 63-position wheel magazine
and chip conveyor option

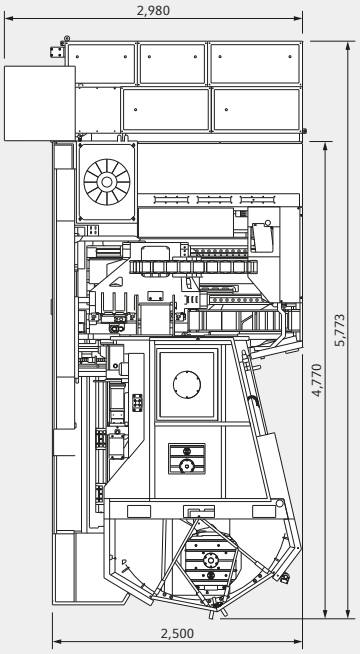
Installation area: 10.2 m² (15.1 m² with chip conveyor)



DMC 60 H *linear*
with pallet changer

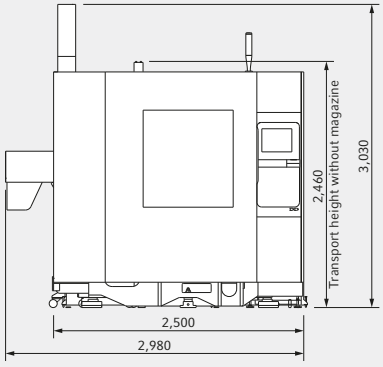
Plan view with 63-position wheel magazine
and chip conveyor option

Installation area: 11.9 m² (17.2 m² with chip conveyor)



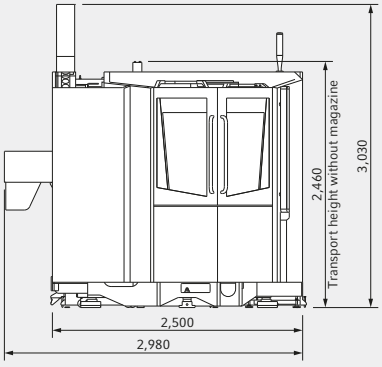
DMC 60 H *linear*
Powertrain machine with no pallet changer (optional)

Frontal view with 63-position wheel magazine
and chip conveyor option



DMC 60 H *linear*
with pallet changer

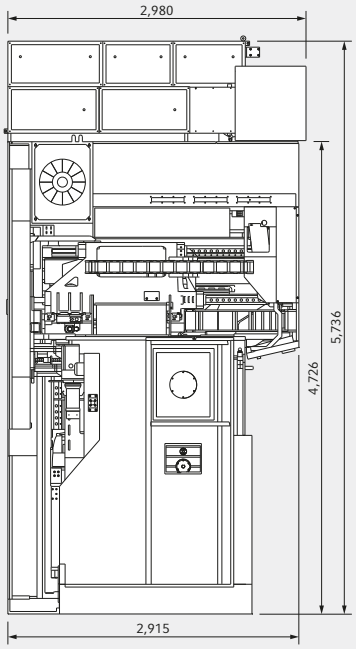
Frontal view with 63-position wheel magazine
and chip conveyor option



DMC 80 H *linear*
Powertrain machine with no pallet changer (optional)

Plan view with 63-position wheel magazine
and chip conveyor option

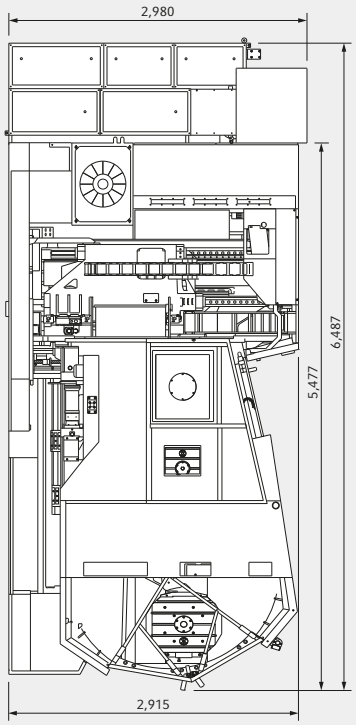
Installation area: 14.1 m² (21.5 m² with chip conveyor)



DMC 80 H *linear*
with pallet changer

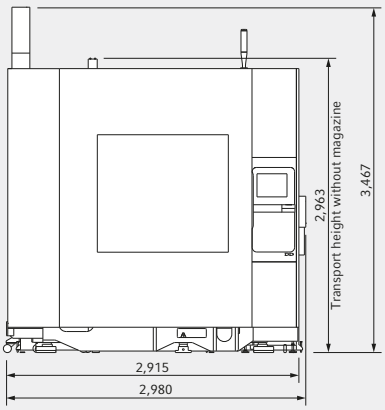
Plan view with 63-position wheel magazine
and chip conveyor option

Installation area: 16 m² (19.3 m² with chip conveyor)



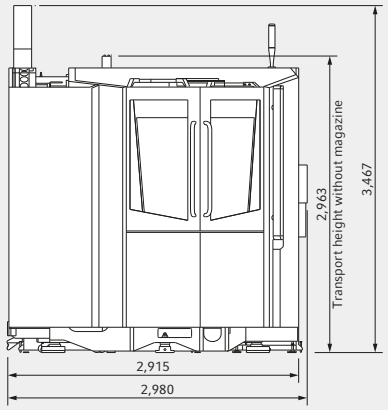
DMC 80 H *linear*
Powertrain machine with no pallet changer (optional)

Frontal view with 63-position wheel magazine
and chip conveyor option



DMC 80 H *linear*
with pallet changer

Frontal view with 63-position wheel magazine
and chip conveyor option



DMC 60 / 80 H *linear*

Technical data

		DMC 60 H *linear*	DMC 80 H *linear*
Working area (HSK-A63)			
X / Y / Z axis	mm	630 / 800 / 850	800 / 900 / 1,050
Distance from spindle centre to pallet	mm	100	150
Distance from spindle nose to pallet centre	mm	70	150
Table / workpiece mounting surface / workpieces			
NC rotary table	rpm	40	40
Pallet size	mm	500 × 500	630 × 630
Loading / without pallet changer	kg	600 / 650	900 / 950
Workpiece diameter / height	mm	800 / 1,030	1,000 / 1,100
Main drive			
Integrated HSK-A63 motor spindle	rpm	12,000	12,000
Power (40 / 100 % DC)	kW	20 / 20	20 / 20
Torque (40 / 100 % DC)	Nm	110 / 84	110 / 84
Run-up time to 12,000 rpm	Seconds	1	1
Tool change system			
HSK-A63 tool magazine	Stations	40 / wheel	40 / wheel
Max. diameter and length	mm	ø 280 × 160 / 400	ø 400 × 280 / 470
Max. tool length / diameter	mm	550 / ø 80	650 / ø 80
Weight / breakdown torque	kg / Nm	15 / 25	15 / 25
4-axis / 5-axis machine chip-to-chip time	Seconds	2.5 / 2.5	3.1 / 3.1
Linear axes (X / Y / Z)			
Cutting feed / rapid traverse	m/min	100	80
Acceleration	m/s^2	10	9
Feed force (X / Y / Z)	kN	9 / 6 / 9	9 / 6 / 14
$P_{max.}$ (X / Y / Z) – VDI DGQ 3441 / ISO 230-2	µm	5	5
$P_{smax.}$ (X / Y / Z) – VDI DGQ 3441 / ISO 230-2	µm	3	3
Machine data			
Footprint without chip conveyor	m^2	11.9 / 10.2*	16 / 14.1*
Machine height	m	3	3.5
Machine weight	kg	13,500 / 10,500*	20,000 / 15,000*

Control systems	
DMG SLIM*line*® Control with 15" monitor	Siemens 840D solutionline Operate
DMG SLIM*line*® Control with 15" monitor	Heidenhain TNC 640

* As a powertrain variant with no pallet changer

DMG MORI
recommends
eni
eni.com

High durability with **stainless steel covers in the working area.** Steep walls and covers for optimised chip flow.

Linear drives in X / Y / Z with **up to 1 g acceleration. 60-month warranty** on the linear drives.

Options

	DMC 60 H *linear*	DMC 80 H *linear*
Siemens 840D solutionline	o	o
Heidenhain TNC 640	o	o
5-axis model with swivelling rotary table	o	o
Clamping hydraulics for the work table / set-up station (with a pallet changer)	o	o
RS7 / RS12 rotary pallet storage for the pallet changer (including 7 / 12 additional pallets)	o	o
Wheel magazine (HSK-A63) 63 / 93 / 123 / 183 / 243* / 273** / 303* / 363** positions	o	o
Wheel magazine (HSK-A100) 63 / 123 / 183 / 243 positions	–	o
Control console for tool magazine loading station	o	o
Infrared measuring sensor (TS 649 DMG or OMP 60)	o	o
BLUM laser tool measurement in working area	o	o
Tool breakage monitoring during machining	o	o
Scraper belt chip conveyor including 500-litre coolant tank	o	o
80-bar internal coolant supply production package with chip conveyor, paper belt filter, 980-litre tank and RotoClear	o	o
Control system options including 3D processing, TRANSMIT, TRAORI, CompCad etc.	o	o
MPC – Machine Protection Control	o	o
TRANSMIT lateral surface transformation	o	o
CompCad compressor function	o	o

o Optional, – Not available, * Only for the DMC 60 H *linear*, ** Only for the DMC 80 H *linear*

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